



Work Order ID 64782

Page 1


Friday, December 17, 2010 7:52:04 AM

Item ID: D3414-041 Accept  Setup Start 
Revision ID: Stop 
Item Name: Lug Assembly
Start Date: 12/16/2010 Start Qty: 10.00  Cust Item ID:
Required Date: 1/19/2011 Req'd Qty: 10.00  Customer:
Reference:

Approvals: Process Plan: PA Date: 10-17-10 Tooling: Date: Run Start 
QC: Date: SPC (Y/N): Date: Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D3414	Rev C								

100 0.00

Waterjet Memo 0.00 B 10-17-08
FLOW CNC Waterjet 1-Cut as per Dwg D3414-1
304 . 100 Dwg Rev: C
Progr Rev: C (14)
2-Deburr if necessary

110 QC2- Inspect parts off machine FAI/FAIB 0.00

QC Memo 0.00 B 10-17-08
Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Friday, December 17, 2010 7:52:04 AM

Page 2



Accept

**Setup Start**

Stop



Start Date: 12/16/2010 **Start Qty:** 10.00

**Cust Item ID:**

Required Date: 1/19/2011 **Req'd Qty:** 10.00



Customer:

Reference:

Run Start



Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

0.00



8/10/03

QC

Memo

0.00

Quality Control

0.00



0.00

Brake NC

Memo

Brake NC

1-Deburr
2-Form using DT8254 as per Dwg D3414

SB 10/11/03

0.00



0.00

Large Fab

Memo

1- Weld using location Jig DT9625 as per Dwg D3414
A/R S.S. welding rod Batch: *M107051*

EL 11-1-18

x 14

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150  QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00		Pl 11-01-19					
160  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	Sulalig						
170  Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum M115951 Memo START TIME: 11:15 OVEN TEMPERATURE: 700° FINISH TIME: 11:45.	0.00 0.00							14. BR 11-2-24

W/O:		WORK ORDER CHANGES					
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Friday, December 17, 2010 7:52:04 AM



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Item ID: D3414-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Lug Assembly

Start Date: 12/16/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 1/19/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

14, 0 11/01/24

190

Identify as per dwg & Stock Location: 473

0.00



Packaging

Memo

0.00

Packaging

11/1/25 TUD SP

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/01/26 J

MF
11-01-25

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, December 17, 2010 7:52:09 AM

Page 1

Work Order ID: 64782

Parent Item: D3414-041

Parent Item Name: Lug Assembly



Start Date: 12/16/2010

Required Date: 1/19/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP A 05.09.13 New issue KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S12GA

Purchased

No

100

sf

195.3000

0.155

1.55

22



304/316 0.100" Sheet



18 10-12-28

Location

Loc Qty

Loc Code

MAT19

195.3

112290

6.3

112611

29

113062

128

113077

32

112290

(14)

D3414-3

Manufactured

No

140

Each

14.0000

1

10



EL 11-1-19

Lug

Location

Loc Qty

Loc Code

ST

14

62978

14

14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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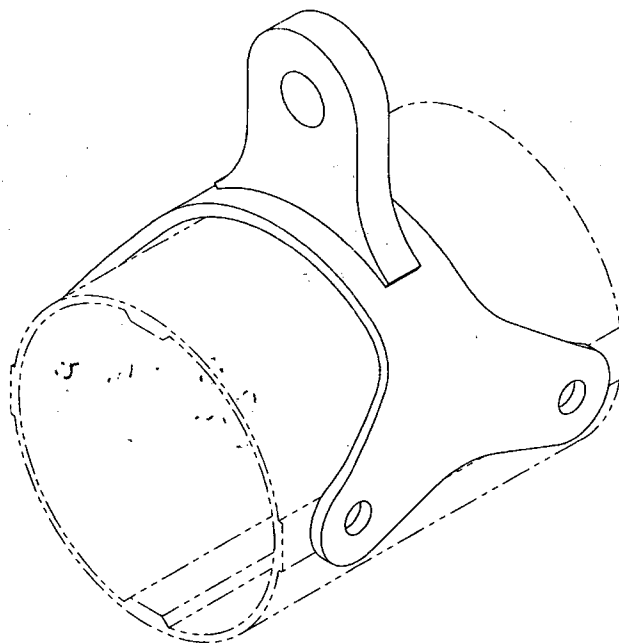
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ITEM No.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D3414-041	LUG ASSEMBLY
2	1	D3414-1	LUG BRACKET
3	1	D3414-3	LUG



D3414-041 LUG ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3414-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.52 lbs

SHOP
RETURN
ENGINEERING
UNCONTROLLED
SUBJECT TO APPROVAL
WITHOUT NOTICE
WORK ORDER
NO. 64282
2/10-12-17

RELEASED
[Signature]

C	BREAK SHARP EDGES FOR .3 NOW 0.030-0.060 WAS 0.010-0.030 (ZN A7-3)	CP	09.06.17
B	DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERRED TO "B" SIZE BORDER. FLAT PATTERN FOR .1 INCREASED IN LENGTH TO PREVENT FOULING AT INSTL (SEE PAR198). FLAT SPOTS REMOVED FROM .1 (PART NOW "U" SHAPED) FOR EASE OF MANUFACTURE. B7-3 ADDED TOLERANCE TO 3.230 DIM. C2-3 1.12 DIM WAS 1.20.	AJS	08.09.23
A	NEW ISSUE	CP	05.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	CP		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3414	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	LUG ASSEMBLY	NTS
DATE	09.06.17	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

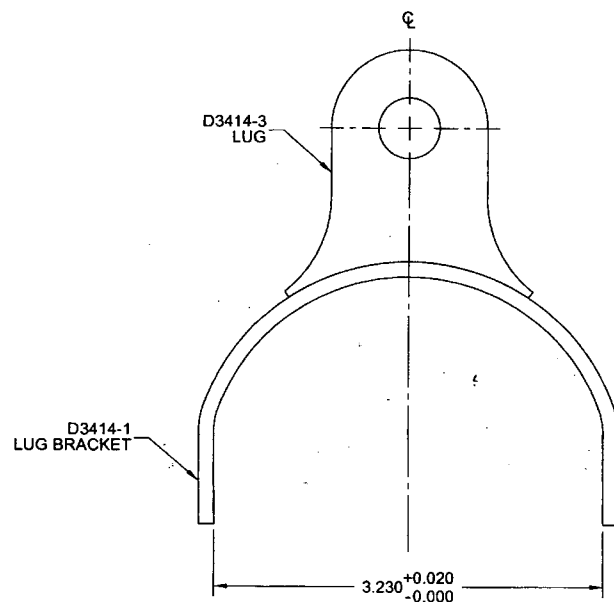
W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

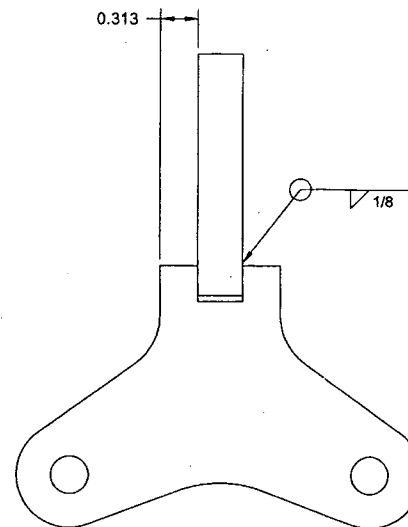
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NOTE: Date & initial all entries



D3414-041 LUG ASSEMBLY



W064782

RELEASED
09/18/17

DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	CP		
CHECKED	<i>[Signature]</i>	DRAWING NO. D3414	REV. C
MFG. APPR.	<i>[Signature]</i>	SHEET 2 OF 3	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	LUG ASSEMBLY	NTS
DATE	09.06.17	<small>COPYRIGHT © 2005 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

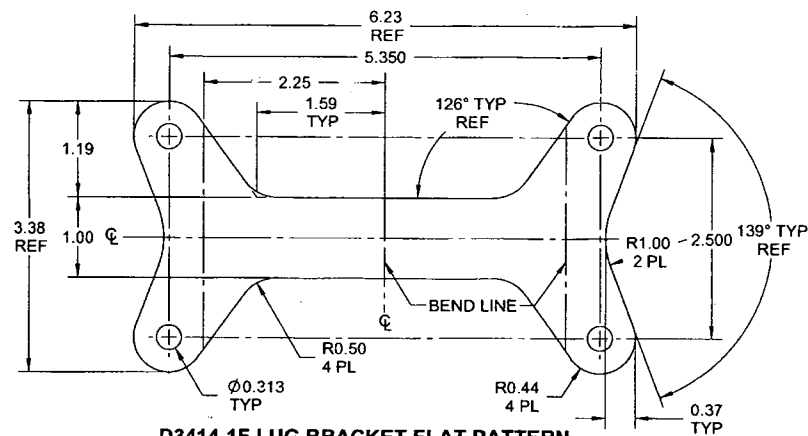
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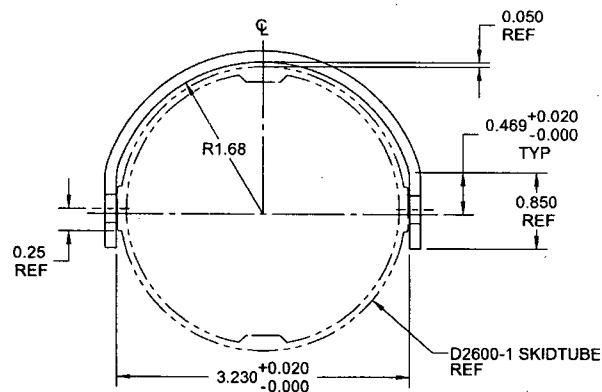
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D3414-1F LUG BRACKET FLAT PATTERN

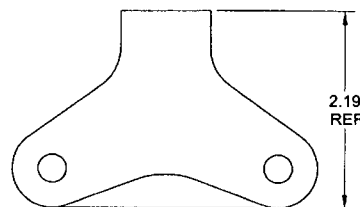


D3414-1 LUG BRACKET

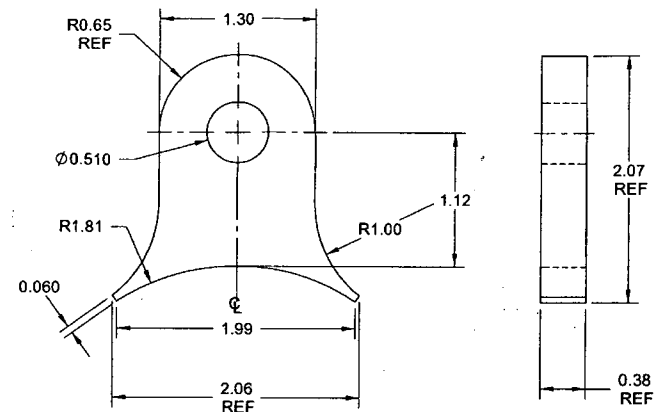
NOTES:
1) MATERIAL: -1: AISI 304/316 STAINLESS STEEL SHEET, 12 GAUGE (0.100 THICK)
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S12GA

-3: AISI 304/316 STAINLESS STEEL PLATE
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S

- 2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: -1: 0.010 TO 0.020 MAX
-3: 0.030 TO 0.060 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: N/A



SIDE VIEW FOR REF ONLY



D3414-3 LUG

RELEASED

DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	CP		
CHECKED	CP	DRAWING NO. D3414	REV. C
MFG. APPR.	CP	TITLE LUG ASSEMBLY	SCALE NTS
APPROVED	CP	DATE 09.06.17	
DE APPR.	CP	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

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